

# Work Order ID 70741

Tuesday, June 14, 2011 10:02:49 AM



Page 1

Item ID: D4277-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*MK*

Date: 11-06-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4277	D

100 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4277  
2- Remove marking, deburr

SAD

11-06-14

①

110 QC6- Inspect dimensions to drawing 0.00



QC

Memo

0.00

Quality Control

QC 11-06-14

120 Identify as per dwg & Stock Location: *WMA* 0.00



Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN BASKET CELL\*\*\*

SAD 11-06-14

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Abstract**

Tuesday, June 14, 2011 10:02:49 AM

**Accept**

[illegible]**Setup Start**

**Abstract**

**Stop**

[REDACTED]

**Cust Item ID:**

**Customer:**

Run Start

[illegible]

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

\_\_\_\_\_

QC

## Memo

0.00

### Quality Control

11/6/15

①

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, June 14, 2011 10:02:47 AM

Page 1

Work Order ID: 70741

Parent Item: D4277-9

Parent Item Name: Rib



Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

878.6205

1.125

1.184211



SAD

11-06-14

Square Tubing

Location

Loc Qty

Loc Code

MAT034

878.6205

116610

0.8383

117721

273.7822

117999

604

1.1843

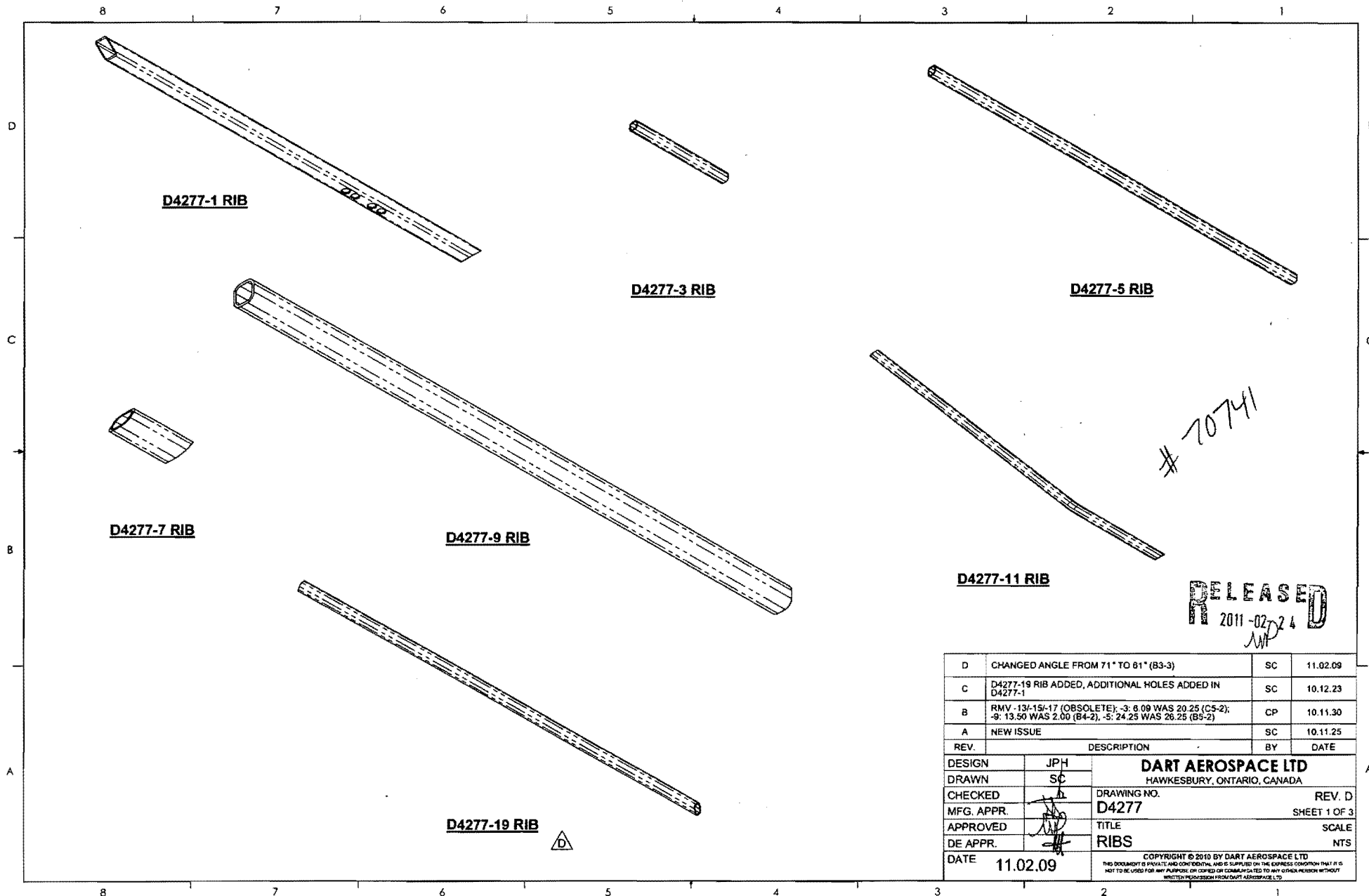
W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



**RELEASED**  
2011-02-24

REV.	DESCRIPTION	BY	DATE
D	CHANGED ANGLE FROM 71° TO 81° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV - 13/15/17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4277</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIBS</b>	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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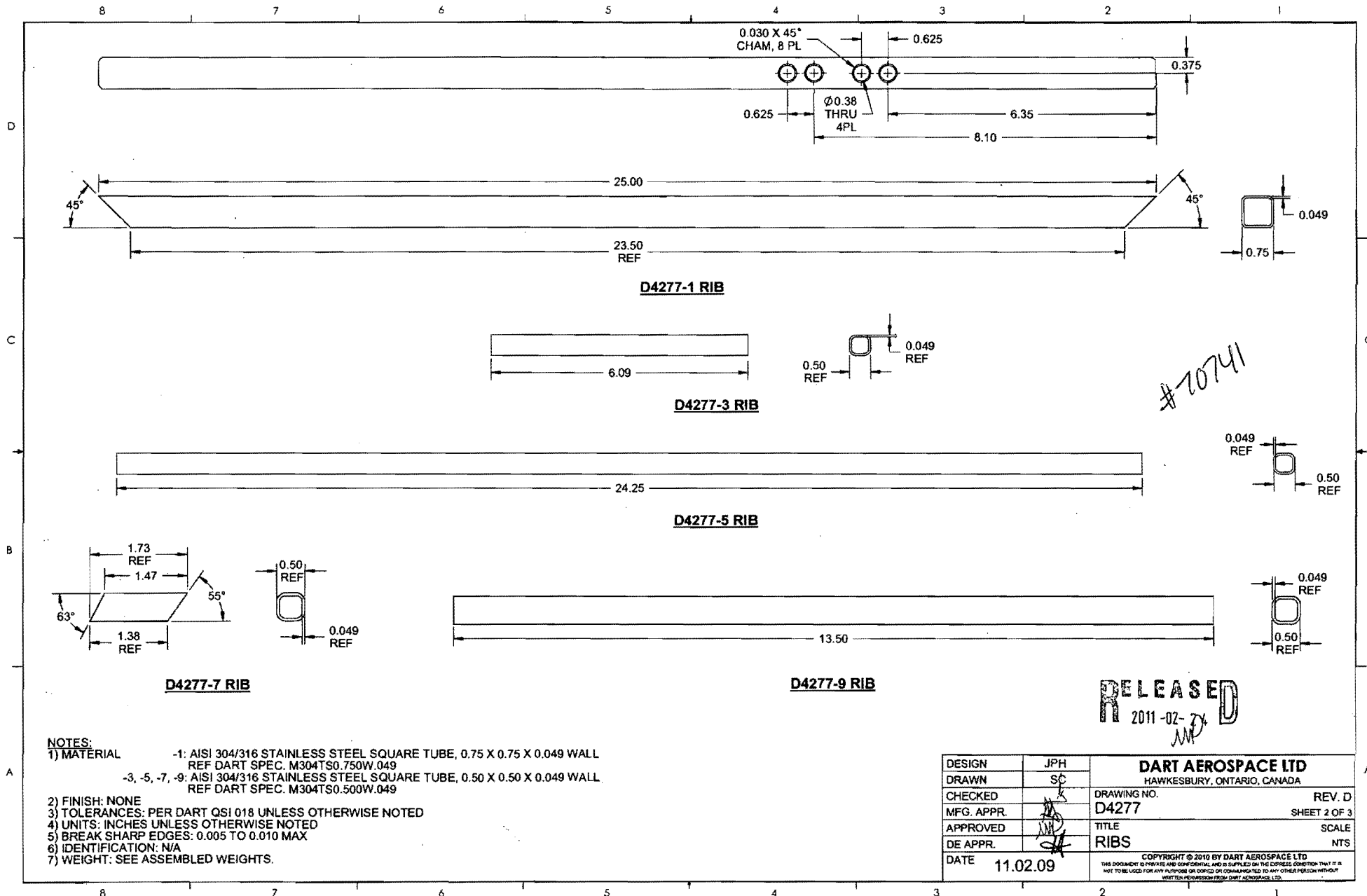
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

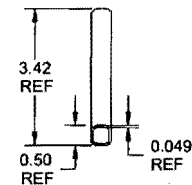
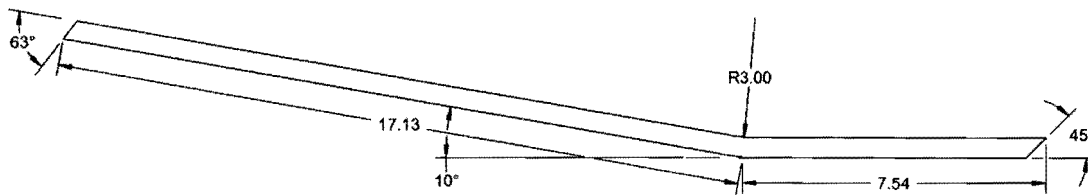
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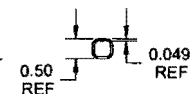
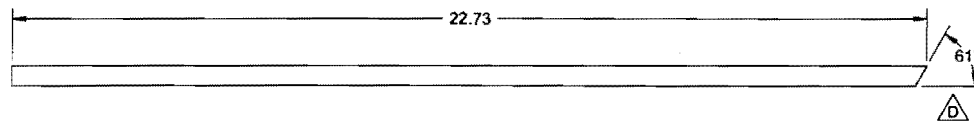
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**D4277-11 RIB**



**D4277-19 RIB**

#70741

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4277</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIBS</b>	NTS
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